

FINISH: EPOXY PRIMER PER MIL-P-23377E TYPE 1, CLASS 1
WEIGHT: 0.50 LBS.

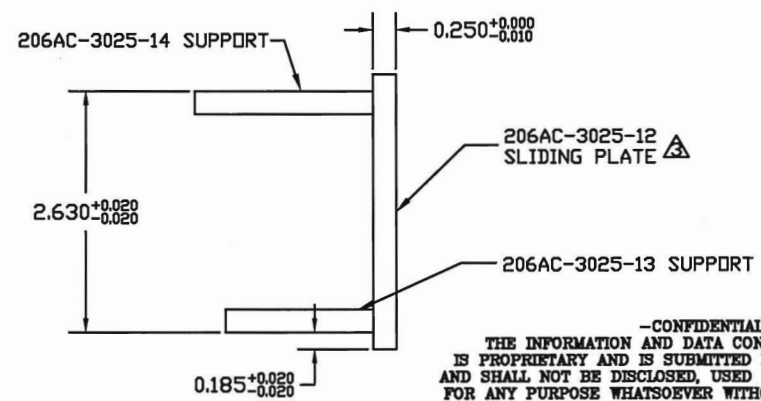
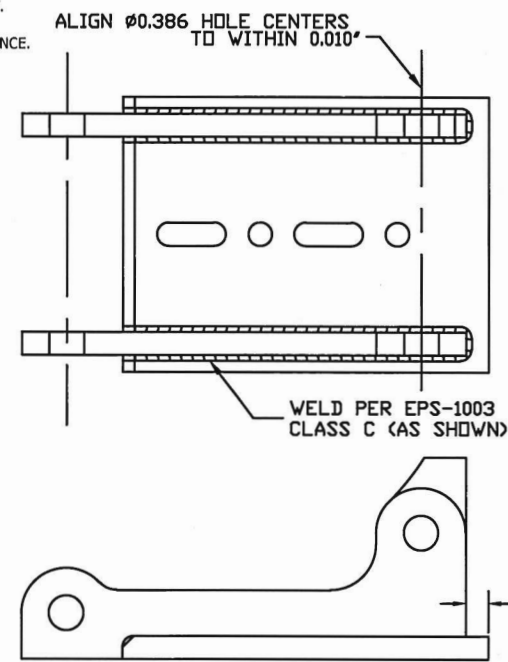
ALT FINISH AND PAINT:
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N. Δ
PAINT ADHESION TEST: Δ

Δ PREPARE PART FOR PRIMER:
a. USE EXTRA CAUTION AND WEAR GLOVES WHILE PREPARING PARTS FOR PRIMER.
b. THOROUGHLY CLEAN ANODIZED PART USING ISOPROPYL ALCOHOL.
c. USE COMPRESSED AIR FREE OF WATER AND CONTAMINANTS.

Δ PAINT ADHESION TEST:
FOR BOTH DRY AND WET TESTS, USE A TAPE WITH AN ADHESION TO STEEL OF 70 OZ/IN MINIMUM.
a. DRY TAPE TEST DONE ONCE EVERY LOT.
i. PLACE THE TAPE ON THE PRIMERED SURFACE AND AFFIX WITH FIRM PRESSURE.
ii. REMOVE THE TAPE WITH AN ABRUPT MOTION (JERK).
iii. LOSS OF ADHESION TO THE BASE MATERIAL CONSTITUTES A FAILURE.
b. WET TAPE TEST DONE ONCE PER MONTH.
i. SOAK THE PART WITH DISTILLED OR DEIONIZED WATER FOR 24 HRS.
(ALTERNATIVELY: AN ANODIZED COUPON WITH AN AREA ABOUT 4 INCHES X 4 INCHES MAY BE USED)
ii. DRY THE SURFACE WITH A CLEAN CLOTH.
iii. REPEAT STEPS i THRU iii OF DRY TAPE TEST.

Δ AFTER WELDING, MACHINE TO MEET TOLERANCE.
a. PLATE MINIMUM THICKNESS 0.240".

ECO	SHEET	REV	DATE	DESCRIPTION	BY	CHK	APR
	1,2,3	A	07/01/99	ADDED 0.020" THICK GROOVE ON SHT 3 CHANGED DIMENSIONS ON SHEET 2 TO MAINTAIN POSITION OF SUPPORT	PR	LS	PR
	1,2	B	07/28/00	REDUCED HEIGHT OF -14 SUPPORT FROM 2.77 TO 1.95	MR	LS	MR
	1,2,3	C	11/23/16	ADDED ALTERNATE MATERIAL SPEC FOR -12,-13,-14; CHANGED THE ALTERNATE FINISH AND PAINT AND ADDED NOTES 1 AND 2.	EW	LS	EW
	3	D	06/20/18	-12 SLOTS WERE .250 WIDE, SLOT RADIUS WAS 0.125, REMOVED REDUNDANT 0.250 SLOT DIM & ADDED 2X TO UPPER 0.280 DIM.	JT	LS	JT
	1	E	10/11/19	ADDED NOTE 3 AND TOLERANCE FOR SLIDING PLATE ON -1 ASSEMBLY	DT	LS	DT



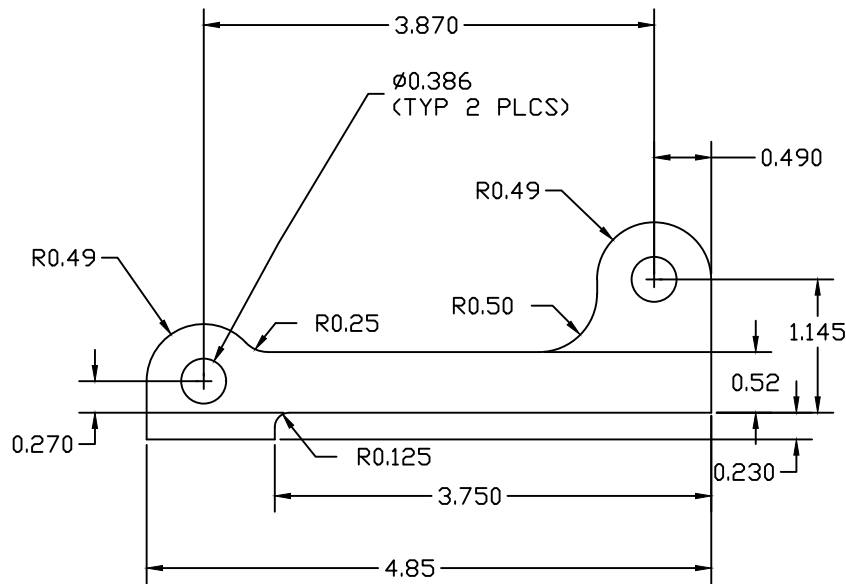
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1	206AC-3025-14	SUPPORT
1	206AC-3025-13	SUPPORT
1	206AC-3025-12	SLIDING PLATE
ASSY	PART NUMBER	DESCRIPTION
QTY.	Paravion® Inc.	TITLE
	Technology	TOP PLATE ASSEMBLY
		DRAWING NO. 206AC-3025
	DIMENSIONS IN INCHES	DRAWN BY DJSH
	TOLERANCES EXCEPT WHERE NOTED:	APRVD BY PR
	.X = ± .1	CHK'D BY LS
	.XX = ± .05	DATE 08/28/98
	.XXX = ± .010	REV E
PROTO	ANGLES = ± 1°	ECO
N/C		DO NOT SCALE DRAWING
		SHEET 1 OF 3

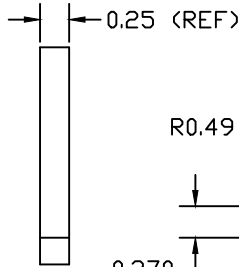
BREAK ALL SHARP EDGES

RELEASE DATE 2023.03.20 - REF ECR 492

MATERIAL: 6061-T6 QQ-A-250/11 AMS 4027 (ALT. AMS QQ-A-200/8 EXT. DR QQ-A-225/8 ROLLED)
STOCK: 0.25 PLATE



-13 SUPPORT



-14 SUPPORT

BREAK ALL SHARP EDGES

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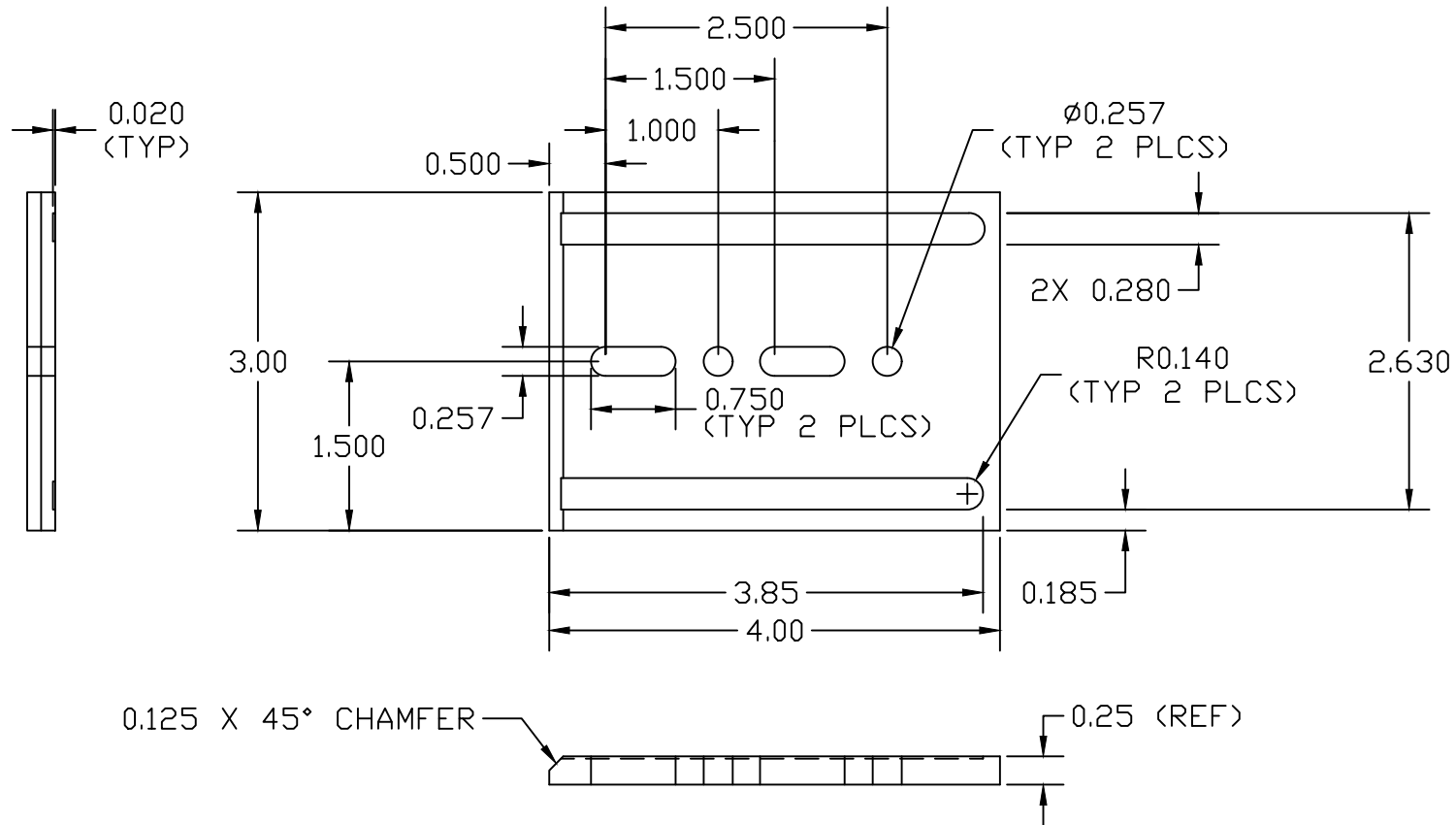
PROTO

N/C

Paravion® Technology Inc.		TITLE TOP PLATE ASSEMBLY		DRAWING NO. 206AC-3025	
DIMENSIONS IN INCHES		DRAWN BY D.JSH	APRVD. BY PR	CHK'D BY LS	DATE 08/28/98
TOLERANCES EXCEPT WHERE NOTED:		ECO			REV E
.X = ± .1 .XX = ± .05 .XXX = ± .010		DO NOT SCALE DRAWING			ECO
ANGLES = ± 1°		© 2019 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY, INC.			SHEET 2 OF 3

RELEASE DATE 2023.03.20 - REF ECR 492

MATERIAL: 6061-T6 QQ-A-250/11 AMS 4027 (ALT. AMS QQ-A-200/8 EXT. OR QQ-A-225/8 ROLLED)
STOCK: 0.25 PLATE



-12 SLIDING PLATE

BREAK ALL SHARP EDGES

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PROTO

N/C

Paravion® Technology Inc.		TITLE TOP PLATE ASSEMBLY		DRAWING NO. 206AC-3025	
DIMENSIONS IN INCHES		DRAWN BY	APRVD. BY	CHK'D BY	DATE
TOLERANCES EXCEPT WHERE NOTED:		DJSH	PR	LS	08/28/98
.X = ± .1		ECO		REV	ECO
.XX = ± .05		DO NOT SCALE DRAWING		E	
.XXX = ± .010		© 2019 PARAVION TECH., INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY, INC.		SHEET 3 OF 3	
ANGLES = ± 1°					